



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-3700-C-01

Job Sheet 170588



Part No: RBE350A94-3700-C-01

Job Qty: 18 ea

Part Name: Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-3700-C-01 Rev 6 IPP Rev A 18.01.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea		2/13/18	0.00	0.00	Start Up Machining-2		18-2-20
110	CNC Lathe	18 pcs		2/13/18	0.00	4.50	MORI SL-154		18
120	QC	18 pcs		2/13/18	0.00	0.00	QC2 Machining-4		18
130	QC	18 pcs		2/13/18	0.00	0.00	QC8 Machining-4	DAS 38	18-02-21
140	QC	18 pcs		2/13/18	0.00	0.00	QC5	10/17 38	
150	Outsource	18 pcs		2/13/18	0.00	0.00	Outsource4	9-89	AT 18-03-09
160	Packaging	18 pcs		2/13/18	0.00	0.00	Packaging2		AT 18-03-09
170	QC	18 pcs		2/13/18	0.00	0.00	QC6		18-03-09
180	Packaging	18 pcs		2/13/18	0.00	0.00	Packaging3-1		18-03-09
190	QC21-SA	18 Ea		2/13/18	0.00	0.00	QC21	21	18-03-09

Part Op 110 - 1-Machine as per DWG. FB604-FOLIO REV: _____ DWG REV: _____ 2-Deburr 3-Engrave T/N

Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG.

150 - Issue P/O to Groupe Altech; PO 039070 - Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

FEB 22 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-A513-T-0.750W0.058	A513 Seamless Alloy Steel Round Tubing 0.75"dia. x 0.058" Wall	6.8040 (.378 ea)	90-Start up Operation	

5041762

7.53

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 1/17/18 11:29 AM Dart.lajeunesse.marie

Container No: S044222



Part: RBE350A94-3700-C-01

Job No: 170588

Serial No/Batch: S044222

Revision: RBE350A94-3700-C-01

Inspector:

Date: 02/21/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

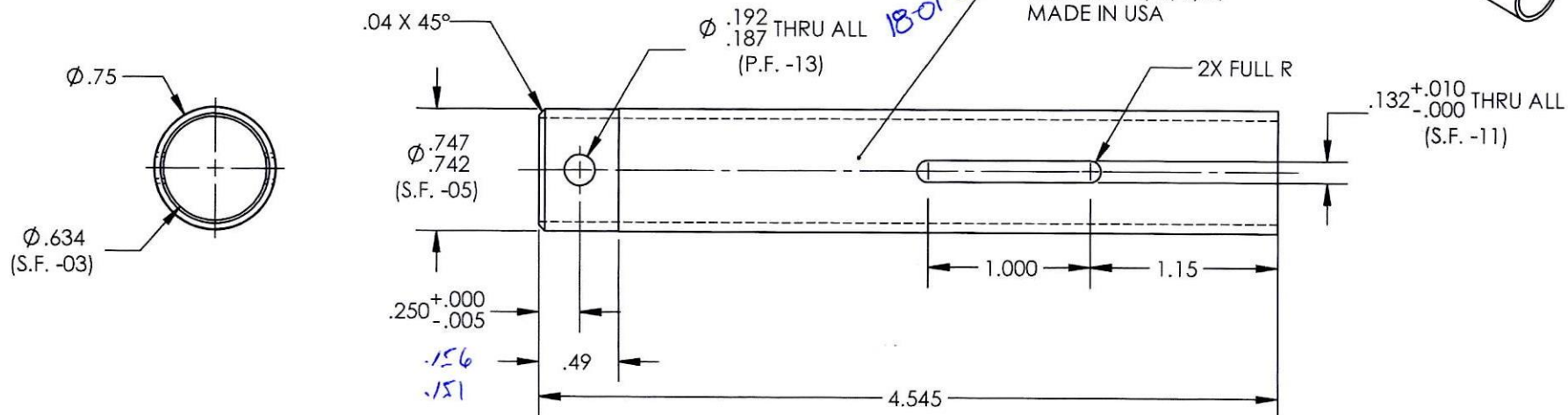
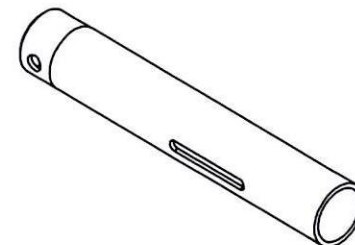
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	15-0213	-01 CHD HOLE WAS Ø.51 mm IS Ø.192-.187.	8/14/2015	RJC	JAG
6	16-0286	-01 CHD DIM WAS Ø.620 S.F. -03 IS Ø.634 (S.F. -03). WAS .250 IS .250 +.000/-.005, WAS .130 THRU IS .132 +.010/-.000 (S.F. -11). WAS Ø.192/.187 THRU IS Ø.192/.187 THRU ALL (P.F. -13), DELETED DIM Ø.750 ∇ .47 MIN S.F. -05. ADDED DIM Ø.747/.742 (S.F. -05). .49, 2X FULL R. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	2/28/2017	RJC	SM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170588 MJS



(01)

TUBE

DART AEROSPACE	
TITLE SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE	
DWG NO. RBE350A94-3700-C-01	REV 6
MATL STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125/✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: MACKOVJAK	EUROCOPTER AS350/355
SCALE 1:1	DATE 8/21/2012
SHEET 3 OF 7	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

BLANKET PURCHASE ORDER PO039090

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039090

PO Date: 2/22/18

Due Date: 3/1/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

E-MAILED
MAR 08 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Blanket Order: -

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		RBE350A94-3700-C-01	Tube -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	-		0 pcs	0 pcs	0 pcs	\$1.29/pcs	
Line Item Note parts made from T-A513 Seamless Alloy Steel Round Tubing										
	170588			Firmed	3/1/18	18 pcs	0 pcs	18 pcs	\$1.29/pcs	\$23.22
Sub Total:						18	0	18		\$23.22
2		RBE350A94-3700-A-03	Top -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	-		0 pcs	0 pcs	0 pcs	\$0.89/pcs	
Line Item Note parts made from AISI 1144 Stressproof Steel Hex Bar										
	170585			Firmed	3/1/18	24 pcs	0 pcs	24 pcs	\$0.89/pcs	\$21.36
Sub Total:						24	0	24		\$21.36
3		RBE350A94-3700-C-09	Knurled Nut -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of	-		0 pcs	0 pcs	0 pcs	\$0.95/pcs	



Certificat de Conformité / Certificate of Compliance

(007034-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007034 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
07-Mar-2018		Aman		PO039090				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3700-C-01 Rev.	RBE350A94-3700-C-01 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18	0	0	0
2	RBE350A94-3700-A-03 Rev.	RBE350A94-3700-A-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	24	24	0	0	0
3	RBE350A94-3700-C-09 Rev.	RBE350A94-3700-C-09 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	10	10	0	0	0
4	RBE350A94-3700-C-03 Rev.	RBE350A94-3700-C-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	9	9	0	0	0
5	RBST2120-9 Rev.	RBST2120-9 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
6	RBST1007-9 Rev.	RBST1007-9 BLACK OXIDE FINISH, MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
7	RBE350A93-3303-02-5 Rev.	RBE350A93-3303-02-5 01 -BLACK OXIDE ON SST MIL-DTL-13924D BLACK OXIDE FINISH, MIL-C-23942C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
8	RBE350A93-3303-02-7 Rev.	RBE350A93-3303-02-7 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	20	20	0	0	0
10	RBT18560-5 Rev.	RBT18560-5 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	6	6	0	0	0
11	RBT18582 Rev.	RBT18582 ZINC PLATE, ASTM B633 TYPE 1 SC2	ZINC CH	6	6	0	0	0
13	RBE350A94-3700-C-09 Rev.	RBE350A94-3700-C-09 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	18	18	0	0	0



Certificat de Conformité / Certificate of Compliance

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 www.groupaltech.com

Bon de Livraison / Packing Slip

007034 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.	
07-Mar-2018		Aman				PO039090	
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Quantités / Quantities Comm. Exp/ Qté NC/ Qté /Ordered Shipped NC Qty Scrap/		À venir/ Back Order

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.